

Date: Tuesday, 13/05/2008 9:28:22 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	PLATE
<b>Job Number</b> :	39229		
<b>Estimate Number</b> :	12668		
<b>P.O. Number</b> :		<b>Part Number</b> :	D323835
<b>This Issue</b> :	13/05/2008	<b>Drawing Number</b> :	D3238 REV C
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	/ /	<b>Drawing Revision</b> :	C
<b>Previous Run</b> :	30746	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	30/05/2008
<b>Checked &amp; Approved By</b> :	JLO 08-5-13	<b>Qty:</b>	10 Um: Each
<b>Comment</b> :	: Est Rev:A New Issue 07-01-26 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S020	6061-T6 .020 Sheet
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**Comment:** Qty.: 0.0252 sf(s)/Unit Total: 0.2520 sf(s)  
 6061-T6 .020 Sheet  
 Batch: 3019 HB 8-5-21

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3238  
 Dwg Rev: C  
 Prog Rev: C

HB 8-5-21

2-Deburr if necessary  
 \*\*\*Use cutting file D3238-21-23-25\*\*\*\*\*

02/05/21 (10) Hm

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-5-21

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

02/05/21 (10)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

HB 08-05-21 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/05/2008 9:28:22 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 39229

Part Number: D323835

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(10x)  
SP

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/5/21

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(10x)  
SP

Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 78

8/5/21

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/22  
MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

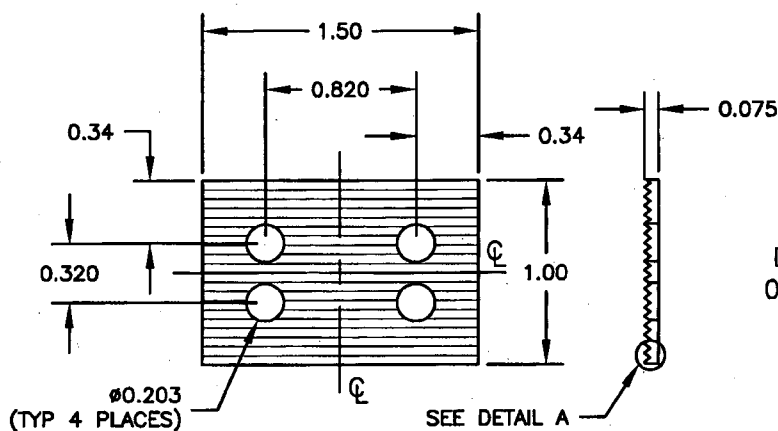
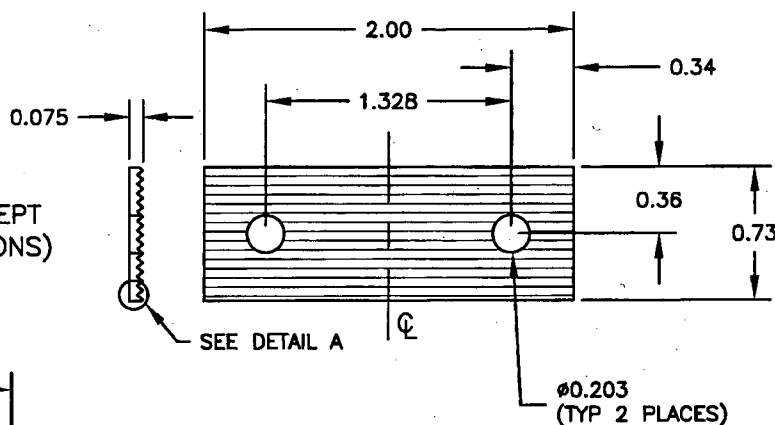
DESIGN #		DRAWN BY CB		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE		APPROVED #		DRAWING NO. D3238	
DATE 07.02.19		TITLE PLATE		REV. C SHEET 1 OF 3	
A	03.11.25	NEW ISSUE			
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6			
C	07.02.19	ADD 5052-H32 OPTION			

RELEASED

07.02.20

**D3238-1 PLATE (SHOWN)**

D3238-11 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**D3238-3 PLATE (SHOWN)**

D3238-13 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

NOTES:

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:  
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S)  
-11/-13/-15/-31/-33/-35 PLATE:  
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR  
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)  
OR  
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR  
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) BREAK ALL SHARP EDGES 0.005 TO 0.010  
4) ALL DIMENSIONS ARE IN INCHES  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) SEE SHEET 3 FOR DETAIL A  
7) PARTS ARE SYMMETRIC ABOUT C
- SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMEND  
WITHOUT NOT  
WORK ORD  
NO. 3922

50/8 SHOP COPY  
OR RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39229

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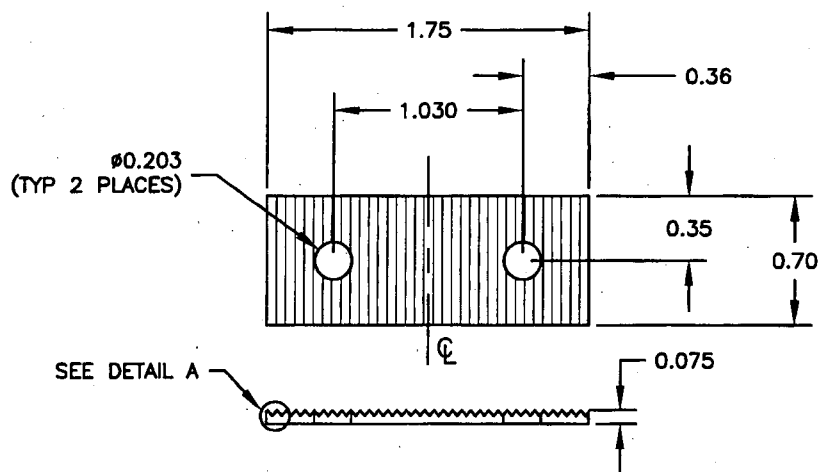
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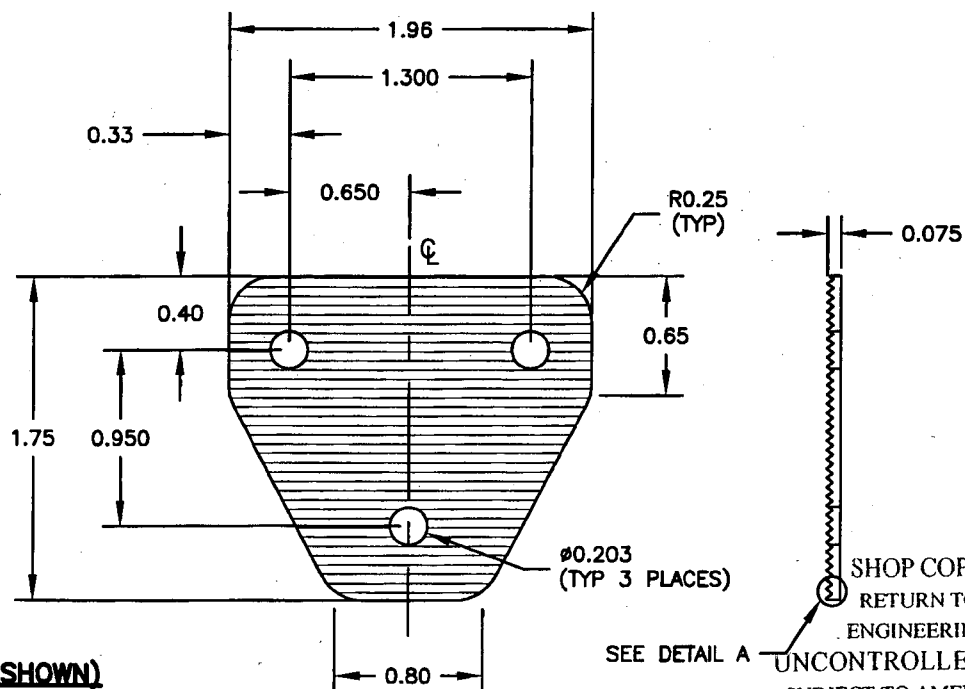
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1

RELEASED

07.02.20



**D3238-5 PLATE (SHOWN)**  
D3238-15 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

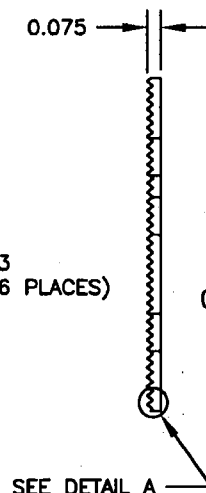
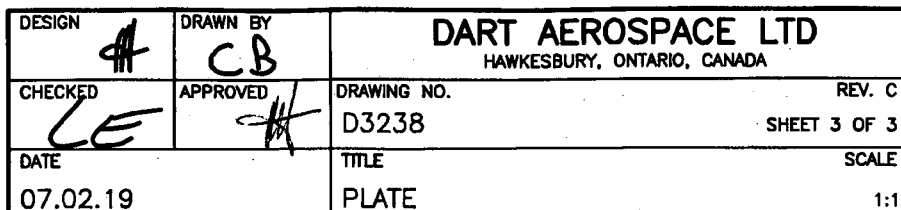


**D3238-21 PLATE (SHOWN)**  
D3238-31 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

SEE DETAIL A  
SHOP COPY  
RETURN TO  
ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39229

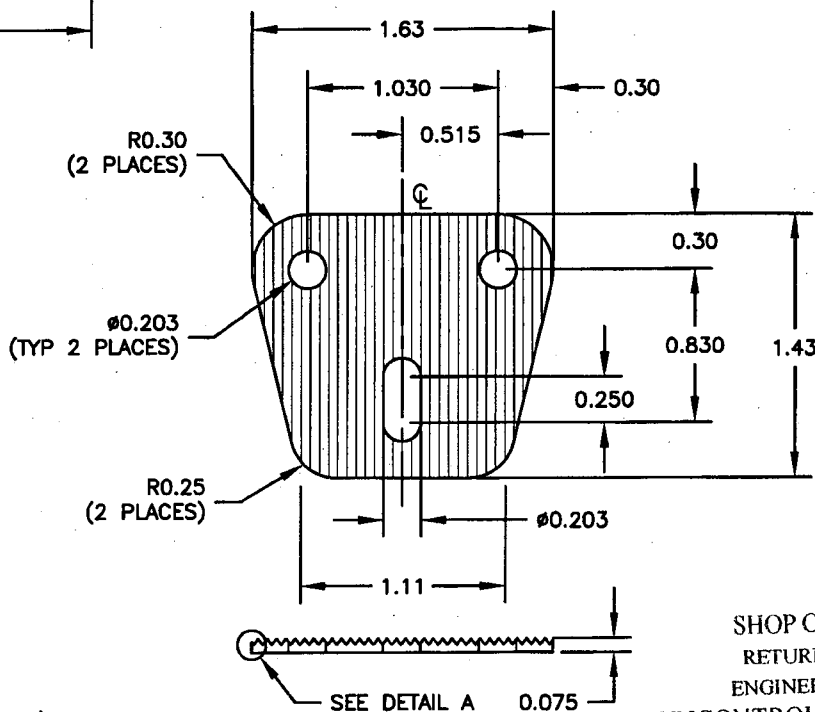
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0702.20

**D3238-23 PLATE (SHOWN)**  
D3238-33 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**DETAIL A**  
RIDGE DETAIL (VIEW MAY BE ROTATED)  
SCALE 10:1

**D3238-25 PLATE (SHOWN)**  
D3238-35 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

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